

Work Order ID 73803

Thursday, September 15, 2011 1:29:49 PM

Page 1

Item ID: DSI 9571-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bolt Substitution

Start Date: 9/15/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9571

A

100

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI 9571-011 CHG001

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

u 11-09-15

Swag16

11/9/15 sf (60)

Swag16

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73803

Thursday, September 15, 2011 1:29:49 PM



Page 2

Item ID: DSI 9571-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bolt Substitution

Start Date: 9/15/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9571-011 Location: <u>20</u>								
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Rev Draft

11/9/15

6

11/9/15

MF
11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 15, 2011 1:29:46 PM

Work Order ID: 73803



Parent Item: DSI 9571-011



Parent Item Name: Bolt Substitution

Start Date: 9/15/2011

Required Date: 9/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 11-09-14 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21042-3 Purchased No



USE MS21042L3

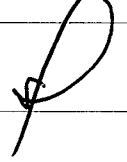
Each 76.0000



12



11/17/601



Location

Loc Qty

Loc Code

ST299

76

114597

70

6931

6

MS21250-03014 Purchased No



BOLT

Each 12.0000



12



11/9/15



Location

Loc Qty

Loc Code

ST305

12

118857

12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-770 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-770 REV. 2

REF. TCCA STC: SH08-8

REF. FAA STC: SR02690NY / SR02070SE

REF. EASA STC: EASA.IM.R.S.01528

REFERENCE
8

1.0 PURPOSE

It is acceptable to replace the AN3C12A Bolts used at the bottom of the D3686-041 Monopod with MS21250-03014 Bolts to prevent premature bolt failure in service. Customers who wish to make this substitution may procure the DSI-9571-011 Kit from Dart.

2.0 INSTALLATION

- 2.1 Temporarily suspend the weight of the engine using appropriate hoist and engine sling.
- 2.2 Unfasten qty(2) AN3C12A Bolts as shown in Figure 1 of this service instruction. Retain the D3692-1 Spacers and discard the AN3C12A Bolts and MS21043-3 Nuts.
- 2.3 Inspect the bearings for looseness in accordance with Section 5.1 of ICA-D205-770.
- 2.4 Install the MS21250-03014 Steel Tension Bolts, D3692-1 Spacers and MS21042-3 Nuts as shown in Figure 2 and ensure that the D3692-1 Spacers are correctly oriented along the face of the stud.
- 2.5 Torque bolts to 20 to 25 in-lbs (2.3 to 2.8 N-m).
- 2.6 Remove hoist and engine sling.

3.0 PARTS LIST

Qty -011	Part Number	Description
X	DSI-9571-011	BOLT SUBSTITUTION KIT
2	MS21042-3	NUT (OR MS21042L3)
2	MS21250-03014	STEEL TENSION BOLT

4.0 WEIGHT & BALANCE






This change has negligible effect on weight and balance

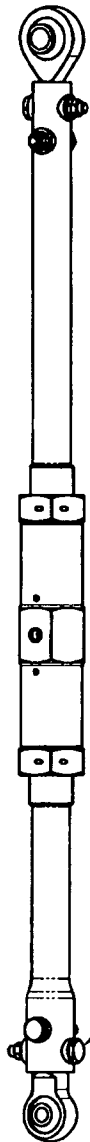
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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

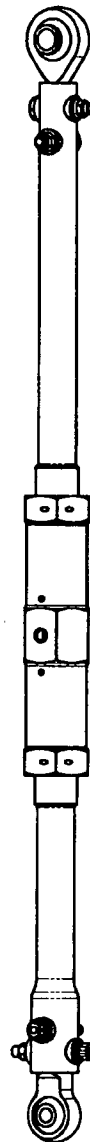
DATE: 11.09.12
CERT. NO.: SH08-8
ISSUE NO.: 1

A	NEW ISSUE	MB	11.09.06
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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APPROVED			
DE APPR.			
DATE	11.09.06		



AN3C12A BOLT
D3692-1 SPACER, 2X
MS21043-3 NUT
2 PL

FIGURE 1 (WAS)



REFERENCE ONLY

MS21250-03014 BOLT
D3692-1 SPACER, 2X
MS21042-3 NUT
2 PL

FIGURE 2 (IS)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.09.12
CERT. NO.: SH08-8
ISSUE NO.: 1

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